

Date: Thursday, 22/05/2008 1:41:17 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FUEL PURGE CANISTER
<b>Job Number</b> :	39406A		
<b>Estimate Number</b> :	10441		
<b>P.O. Number</b> :		<b>Part Number</b> :	D32621
<b>This Issue</b> :	22/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3262 REV C
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38446A	<b>Drawing Revision</b> :	C
	<b>Type</b> :	<b>Material</b> :	
	LARGE FAB ASSY	<b>Due Date</b> :	10/06/2008
<b>Written By</b> :		<b>Qty:</b>	4 Um: Each
<b>Checked &amp; Approved By</b> :	J/JLM		
<b>Comment</b> :	Est. C 05.03.10 Removed P/O for liquid penetrant inspection K		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6T5000W125	6061-T6 Tube 5.00X.125W
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**Comment:** Qty.: 0.9406 f(s)/Unit Total : 3.7624 f(s)  
 Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall  
 (M6061T6T5.000W.125)  
 Identify as D3262-1  
 Batch: M105532

ml 08/06/22

(4)

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
 Cut D3262-1 to length as per Dwg D3262  
 Identify as D3262-1

ml 08/06/22

(4)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

ml 08/06/22

(4)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 08/06/22

(4)

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5 08/06/23 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 22/05/2008 1:41:17 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 39406A

Part Number: D32621

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(4x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 164

8/6/23

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

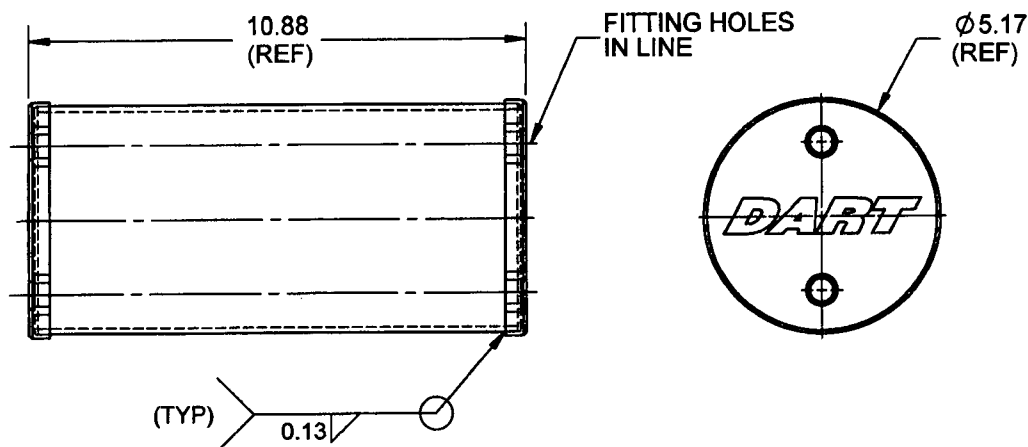
**NOTE:** Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3262</b>	REV. C SHEET 1 OF 2
DATE <b>06.08.31</b>		TITLE <b>FUEL PURGE CANISTER</b>	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø5.165 WAS Ø5.190	

RELEASED  
06.09.19 *[Signature]*

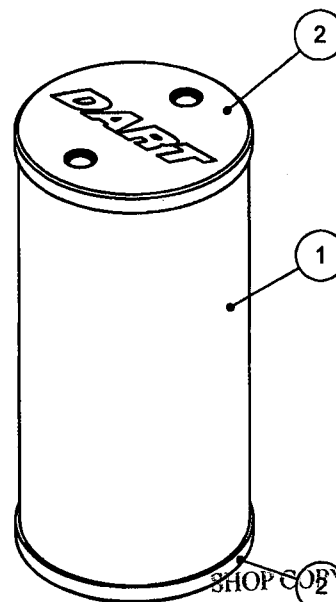


### D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



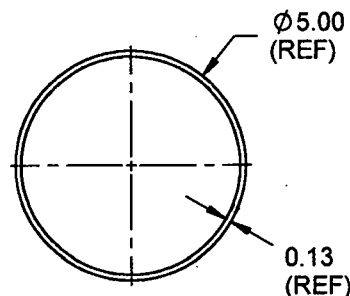
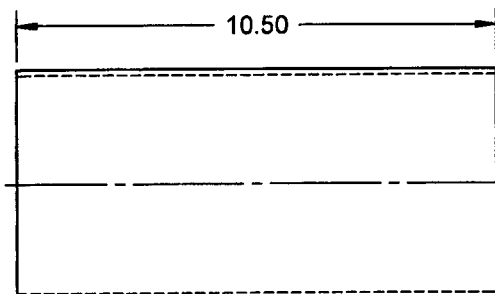
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CHECKED <i>PH</i>	APPROVED <i>B</i>	DRAWING NO. <b>D3262</b>	REV. C SHEET 2 OF 2
DATE <b>06.08.31</b>	TITLE <b>FUEL PURGE CANISTER</b>		SCALE 1:4

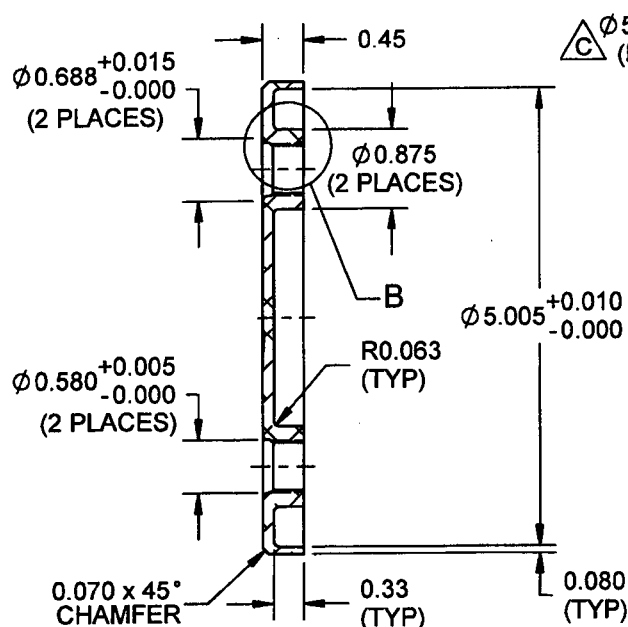


RELEASED

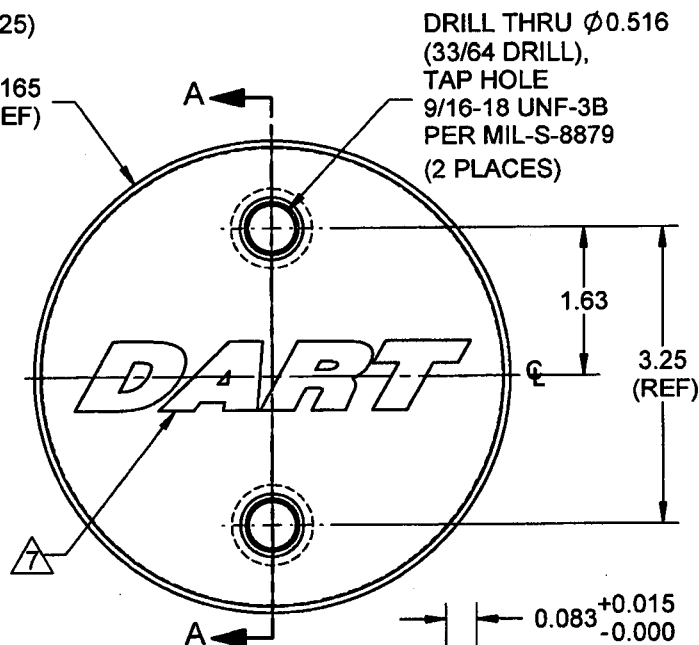
06.09.11.9

### D3262-1 TUBE

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR  
QQ-A-200/8 OR QQ-A-225/8  
(REF. DART SPEC. M6061T6T5.000W.125)



**SECTION A-A**  
SCALE 1:2

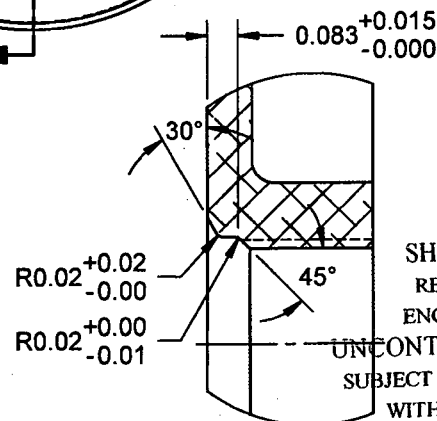


### D3262-3 CAP

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR  
(REF. DART SPEC. M6061T6B)

#### NOTES:

- FINISH: NONE
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- BREAK ALL SHARP CORNERS 0.005 TO 0.010
- PART IS SYMMETRICAL ABOUT CENTERLINE
- ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)



**DETAIL B**  
SCALE 2:1

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